

Work Order ID 94399-2

December-13-12 10:02:44 AM

Page 1

shp ASAP. 1
SPC

94399

Item ID: D4079-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp Half, Attachment

Start Date: 12/13/12 Start Qty: 20.00

20

Cust Item ID:

Required Date: 12/19/12 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4079

B

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.750" long

SL 12-12-19

20

110

0.00

110

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA931

Folio rev: 4A

Dwg Rev: B

Deburr

18

DAS
25
2-89 12-12-19

94399

December-13-12 10:02:44 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 12/13/12 **Start Qty:** 20.00

20

Customer:

Required Date: 12/19/12 **Req'd Qty:** 20.00

20

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 94399

94399

Page 3

December-13-12 10:02:44 AM

Item ID: D4079-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clamp Half, Attachment
 Start Date: 12/13/12 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 12/19/12 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M 121 279 Memo 8:40 320 9/10.	0.00 0.00				18	φ	bf 12-12-20	
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	045 15 89			18			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: 878/2 Memo	0.00 0.00				18		80 12-12-24	

Work Order ID 94399***94399***

Page 4

December-13-12 10:02:44 AM

Item ID: D4079-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp Half, Attachment

Start Date: 12/13/12 Start Qty: 20.00

20

Cust Item ID:

Required Date: 12/19/12 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/1/10

MF
12-12-27

Picklist Print

December-13-12 10:02:43 AM

Page 1

Work Order ID: 94399

Parent Item: D4079-1

Parent Item Name: Clamp Half, Attachment

Start Date: 12/13/12

Required Date: 12/19/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.000 6061-T6 Bar 2.00 x 2.00		Purchased	No			100	f	9.4978	0.23	4.8421053		12-12-12	

Location	Loc Qty	Loc Code
MAT009	9.4978	
113123	0.7754	
119801	7.7324	
13085	0.99	

4.9 ← not pulled nothing in
computer

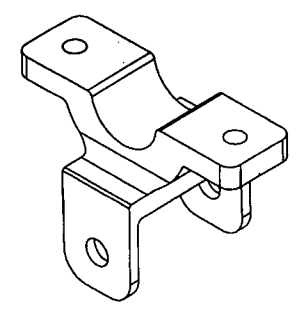
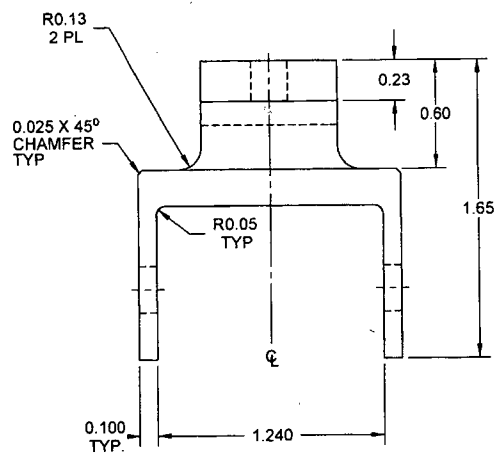
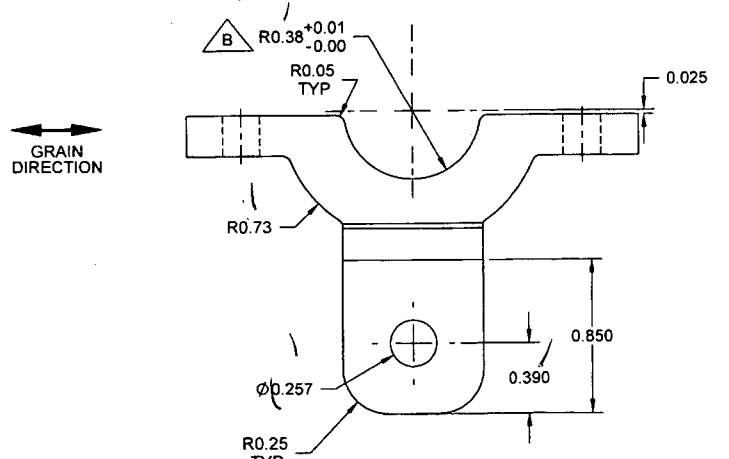
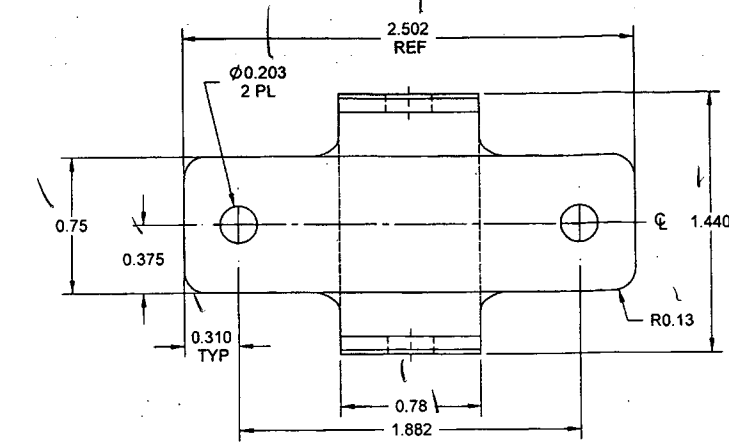
DART AEROSPACE LTD		Work Order:	94399
Description: Clamp Half, Attachment		Part Number:	D4079-1
Inspection Dwg: D4079	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.502	+/-0.010	2.503	✓		Vern	SK-10
Ø0.203	+0.005/-0.001	0.205	✓			
0.75	+/-0.030	0.750	✓			
0.375	+/-0.010	0.375	✓			
0.310	+/-0.010	0.310	✓			
1.882	+/-0.010	1.882	✓			
0.78	+/-0.030	0.780	✓			
R0.13	+/-0.030	0.13	✓			
1.440	+/-0.010	1.440	✓			
R0.38	+0.010/-0.000	0.384	✓		HG	
R0.050	+/-0.010	0.05	✓			
R0.73	+/-0.030	0.730	✓			
Ø0.257	+0.006/-0.001	0.257	✓			
R0.25	+/-0.030	0.250	✓			
0.390	+/-0.010	0.390	✓			
0.850	+/-0.010	0.850	✓			
0.025 x 45°	+/-0.010 x 0.5°	0.025 x 45°	✓			
0.100	+/-0.010	0.101	✓			
R0.05	+/-0.030	0.063	✓			
1.240	+/-0.010	1.240	✓			
1.65	+/-0.030	1.652	✓		HG	
0.60	+/-0.030	0.605	✓			
0.23	+/-0.030	0.225	✓			
0.025	+/-0.010	0.025	✓			

Measured by:	SK	Audited by:	amx	Preliminary Approval:	
Date:	12-10-18	Date:	12/12/29	Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	HA



D4079-1 CLAMP HALF, ATTACHMENT

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4079-1" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.09 lbs

w/094399

RELEASED
2010-09-07
MP

B	R0.38 WAS R0.48.	JB	10.07.30
A	NEW ISSUE	JB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN		JB	
DRAWN		JB	
CHECKED		JB	
MFG. APPR.		JB	
APPROVED		JB	
DE APPR.		JB	
DATE	10.07.30		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4079 TITLE CLAMP HALF, ATTACHMENT SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			